

Work Order ID 51597

August 27, 2009 8:25:21 AM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearshoe

Start Date: 8/27/09 Start Qty: 16.00



Cust Item ID:

Required Date: 8/27/09 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

RLmt

Date: 08-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3793 Deburr if necessary								
	Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

HB 9-10-2

(16)

HB 9-10-2

2) 502/10625

(16)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Deburr if necessary! 2-Form on Brake as per Dwg D3793 using Jigs 3-Form
Joggle on brake using Jig as per Dwg D3793

8/29/06

16

0

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

2) 8/27/06

16

0

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME:

7:20

OVEN TEMPERATURE:

320° FINISH TIME:

7:00

PR 09-10-7

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP-18

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Handwritten: 09/10/09

Handwritten: (X16) 0

Handwritten: 09/10/09

Handwritten: (X16) 0

Handwritten: 09/10/09
09-10-7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	S1597
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.192	*			
0.300 x 0.300	+/-0.010	304 x 307	*			
1.885	+/-0.010	1.884	*			
2.000	+/-0.010	2.000	*			
5.00	+/-0.030	5.00	*			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.066	+/-0.010	14.066	*			
18.983	+/-0.010	18.983	*			
23.900	+/-0.010	23.900	*			
27.400	+/-0.010	27.400	*			
29.400	+/-0.010	29.400	*			
32.900	+/-0.010	32.900	*			
0.040	+/-0.010	0.035	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-10-2	Date: 02/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

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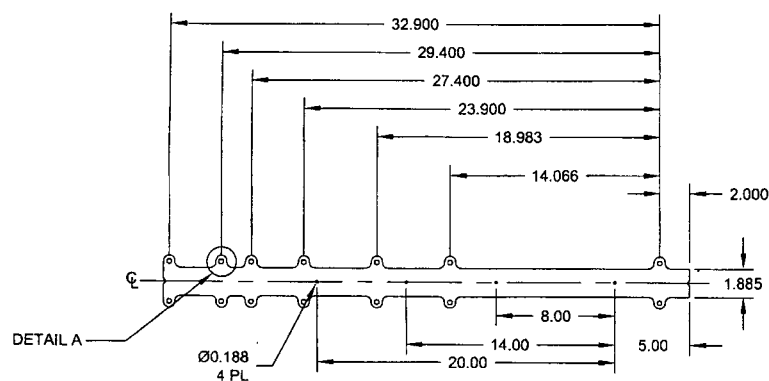
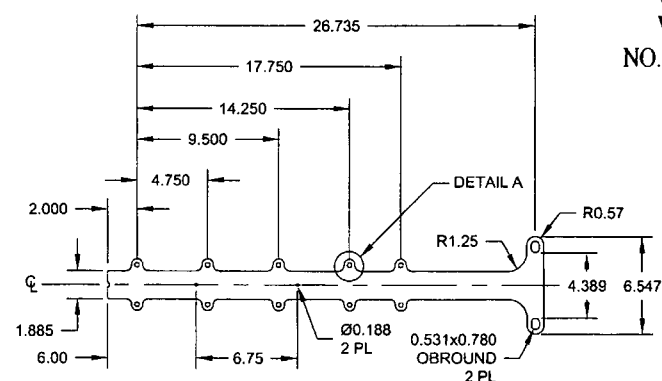
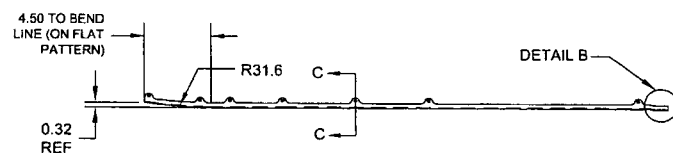
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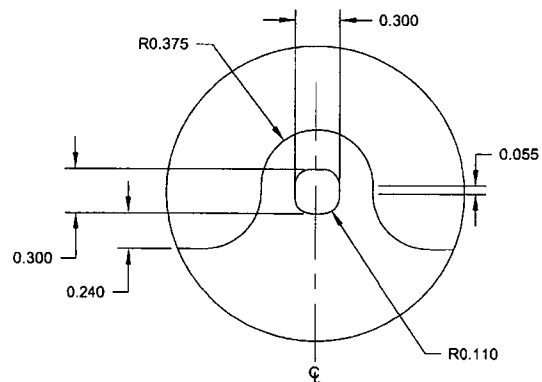
NO. 51597**D3793-1F FLAT PATTERN****D3793-3F FLAT PATTERN****D3793-1 BEND DETAIL**
(MAKE FROM D3793-1F)**D3793-3 BEND DETAIL**
(MAKE FROM D3793-3F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

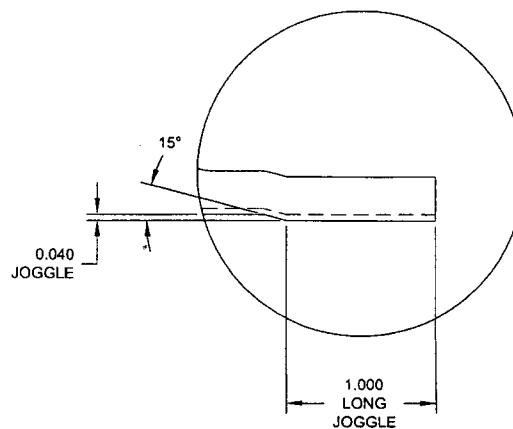
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CHECKED		DRAWING NO.	REV. A		
MFG. APPR.	DS	D3793	SHEET 1 OF 2		
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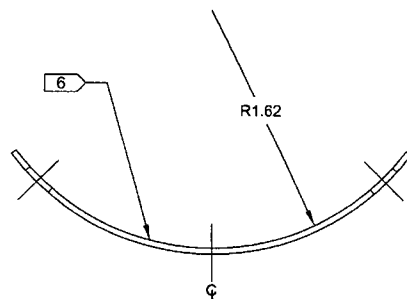
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DETAIL A
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DETAIL B
 SCALE 10X



SECTION C-C
 SCALE 10X

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